

Work Order ID 137291

Thursday, September 24, 2015 1:29:49 PM

647.7501
B137291
REV. A

137291

Oct 19th Page 1

Item ID: 647.7501

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Cutter Assembly

Start Date: 10/13/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/13/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: SEP 25 2015

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7500	A								

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

120 0.00

120

Small Fab Memo 0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M133275
exp. date: 05/17

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

DAS 36 9-89
15/10/13
1X
7
DAS 38 9-89
OCT 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

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Picklist Print

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Page 1

Work Order ID: 137291

137291

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/13/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

647.7813 Manufactured No

Each 6.0000 1

647 7813

Center Plate, Lower

Location

Loc Qty

Loc Code

CCK114

6

113877

2

119679

4

MF 15-9-30

647.7810 Manufactured No

Each 2.0000 1

647 7810

Bracket A

Location

Loc Qty

Loc Code

CCK113

2

135246

2

B 136965 ①

647.7811 Manufactured No

Each 2.0000 1

647 7811

Bracket B

Location

Loc Qty

Loc Code

CCK113

2

135247

2

B 136966 ①

646.3015 Manufactured No

Each 0.0000 2

646 3015

Blade

Location

Loc Qty

Loc Code

CCK113

2

135247

2

B 136966 ①

647.7601 Manufactured No

Each 0.0000 1

647 7601

Lower Deflector Assembly

Location

Loc Qty

Loc Code

CCK113

2

135247

2

B 136966 ①

B 137078 ①

MF 15-9-30

15/10/13 DAS 36 9-89

15/10/13 DAS 36 9-89

15/10/13 DAS 36 9-89

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Page 2

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137291

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/13/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

647.7815 Purchased No

Each 2.0000 1

647 7815

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

2

113878

2

UMF 15-9-30

647.7814 Purchased No

Each 2.0000

1

647 7814

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

2

113879

2

UMF 15-9-30

647.7816 Manufactured No

Each 1.0000

1

647 7816

Aft Bracket

Location

Loc Qty

Loc Code

CCK114

1

120938

1

UMF 15-9-30

647.7817 Manufactured No

Each 1.0000

1

647 7817

Aft Bracket

Location

Loc Qty

Loc Code

CCK115

1

123826

1

UMF 15-9-30

DQA: _____ Date: _____



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Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,949.0000

26

NAS1149FN832P

DAS

OCT 07 2015

Washer

30
9-89

Location

Loc Qty

Loc Code

GA

737

125268

737

ST260a

291

125268

291

st268

921

M130388

921

MS21042-3

MS21042L3

Purchased

No

Each

549.0000

3

MS21042-3

DAS
30
9-89

OCT 07 2015

Nut / use MS21042L3

Location

Loc Qty

Loc Code

CA

501

M129682

501

ST305

48

M128770

10

M129541

15

M130388

23

MS21042-08

MS21042L08

Purchased

No

Each

33.0000

13

MS21042-08

DAS
30
9-89

OCT 07 2015

USE MS21042L08

Location

Loc Qty

Loc Code

ST304

25

122815

25

ST306

8

m130388

8

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Shop Packet Print

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Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Picklist Print

Page 4

Thursday, September 24, 2015 1:29:48 PM

Work Order ID: 137291

137291

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/13/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

1,635.000

6

NAS1149F0332P

DAS
30
9-89

OCT 07 2015

Washer

Location

Loc Qty

Loc Code

GA	180
122063	180
ST260a	136
m128401	6
m131026	80
m131697	50
st268	1319
123900	7
m130388	86
m133077	626
m133134	600

6

MS27039-08-19

Purchased

No

Each

562.0000

7

MS27039-08-19

DAS
30
9-89

OCT 07 2015

Screw

Location

Loc Qty

Loc Code

GA	250
m132930	250
ST260a	100
m133077	100
ST273A	183
m131317	183
ST281	29
m131264	29

7

Thursday, September 24, 2015 1:29:49 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

Thursday, September 24, 2015 1:29:49 PM

Work Order ID: 137291

137291

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 10/13/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-19

Purchased

No

Each

239.0000

3

DAS
30
9-89

OCT 07 2015

MS27039-1-19

Screw

Location

Loc Qty

Loc Code

GA
m124326
ST273A
m133134
ST285
m127904

32
32
200
200
7
7

3

MS27039-08-24

Purchased

No

Each

413.0000

6

DAS
30
9-89

OCT 07 2015

MS27039-08-24

Screw (MS27039-0824)

Location

Loc Qty

Loc Code

CUK007A
ST273A
124326
ST281
125654

297
297
116
116

G A

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

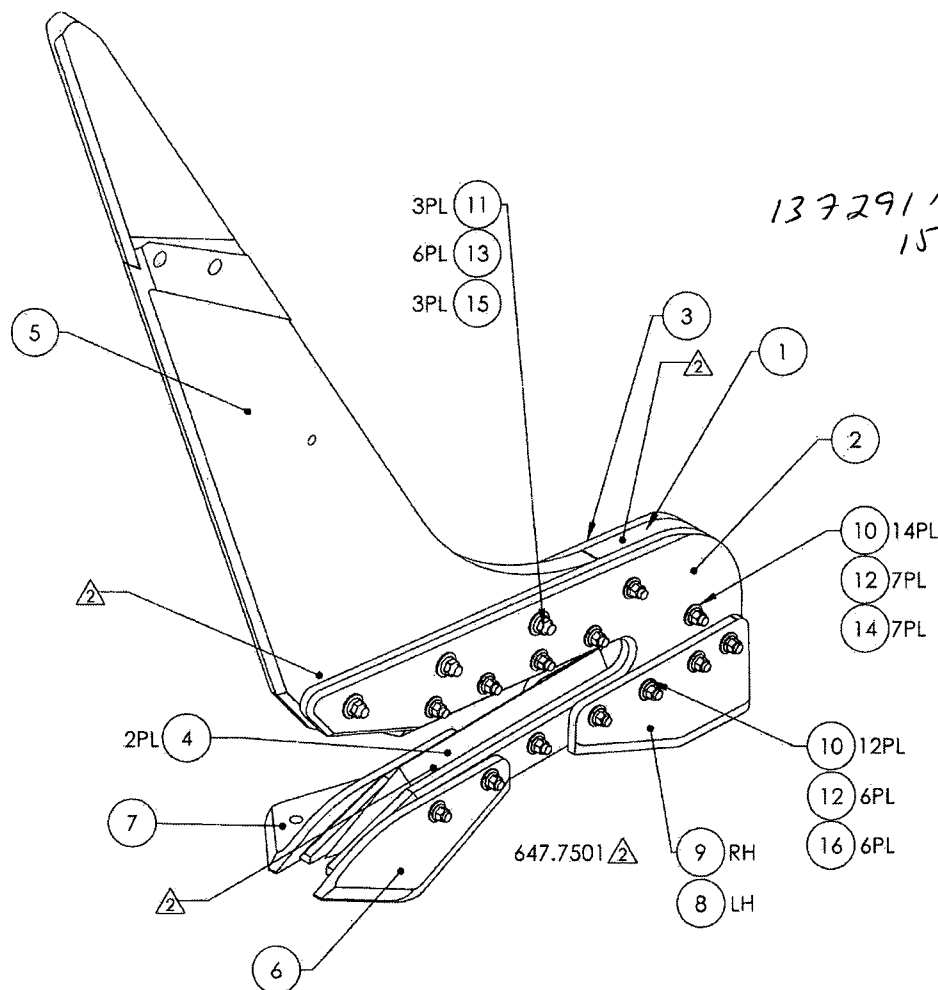
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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NOTES:

1. IDENTIFY IAW MPP-120

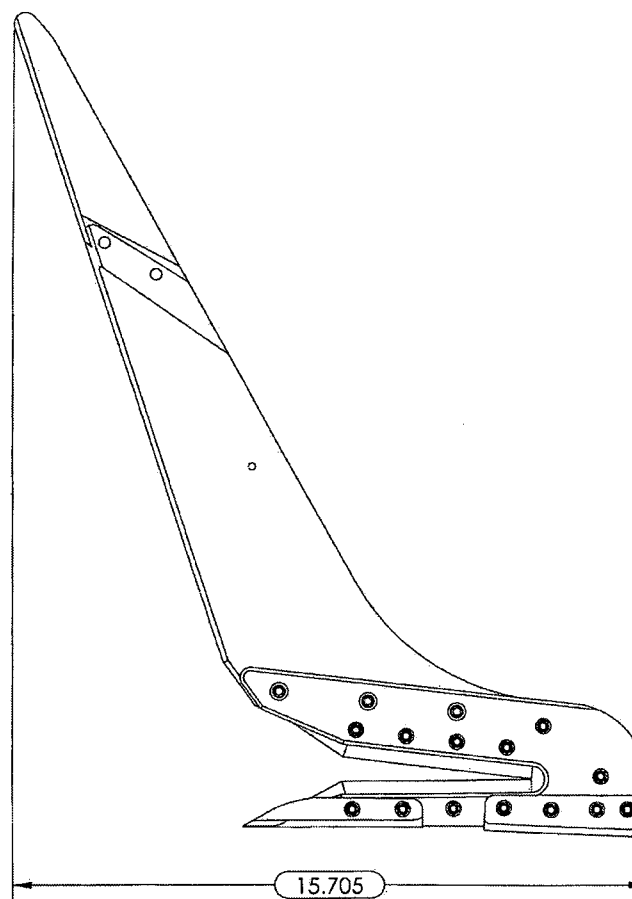
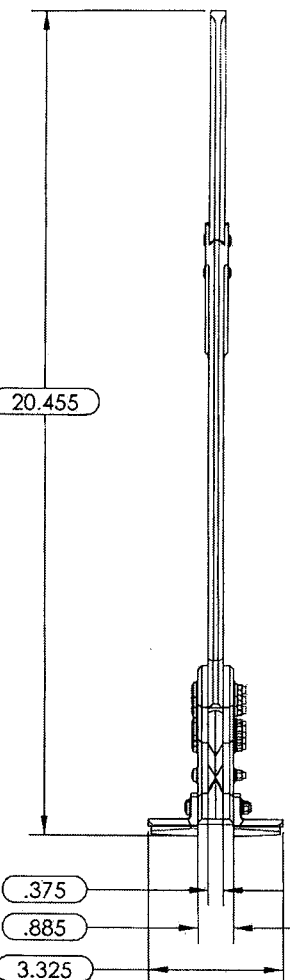
2. APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY



A/R	17	601.2045	RTV, LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
7501	7501	647.7501	LOWER CUTTER ASSY		
QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

PARTS LIST			APICAL INDUSTRIES	
NEXT ASSY (S)			2608 TEMPLE HEIGHTS DR.	
647.7300			OCEANSIDE, CA. 92056-3512 (760)724-5300	
			LOWER CUTTER ASSY	
			647.7500	
			SCALE NONE	
			SHEET 1 OF 2	

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ORIGINAL DATE 11-24-09		APICAL INDUSTRIES	
DRAWN BY A. CASH		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		LOWER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.2°		REV. A	
SIZE B	CAGE CODE 07M26	DWG. NO. 647.7500	
SCALE NONE		SHEET 2 OF 2	